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RBE105-14181W4
Job Sheet 200891



Part No: RBE105-14181W4

Job Qty: 2 pcs

Part Name: Needle Bearings Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 11/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 19502

Note: DWG RBE105-14181W4 Rev.C IPP Rev. A 18.12.10 New issue DP Verify DD/IPP Rev. B 19.09.09 drawing revision DP Verify DD

Ship Via:



Bill of Materials

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Container No: S236714



Part: RBE105-14181W4

Job No: 200891

Serial No/Batch: S236714

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 12/03/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	Sign-off
100	Small Fab - 1	2 pcs	11/14/19		0.00	0.50	Small Fab - 1	
							Small Fab - 2	MLL
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
							Small Fab - 8	
110	QC 5	2 pcs	11/14/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	DEC 03 2019
							QC 5 - 61	
							QC 5 - 81	
120	Packaging 3-1 - Stock - B4B	2 pcs	11/14/19		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - FG	2 pcs	11/14/19		0.00	0.00	QC 21 - FG - 21	
							QC 21 - FG - 70	
							QC 21 - SA - 53	

Part Op 100 - Assemble as per drawing see note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location: _____ The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

DAS
21
9-89

DEC 05 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91290A230 (65)	Black Oxide Steel Socket Head Screw, M5 X 0.8 mm X 14 mm Long	44 Ea (22 ea)	100-Small Fab - 1	5216720
144 RBE105-14181W4-1	Shell	4 pcs (2 ea)	100-Small Fab - 1	5228820
137 RBE105-14181W4-11	Puller	2 pcs (1 ea)	100-Small Fab - 1	5232741
141C RBE105-14181W4-13	Screw	2 pcs (1 ea)	100-Small Fab - 1	5225794
141C RBE105-14181W4-15	Base	4 pcs (2 ea)	100-Small Fab - 1	5217748
137A RBE105-14181W4-17	Clamping Ring	2 pcs (1 ea)	100-Small Fab - 1	5226413

Job Allocations

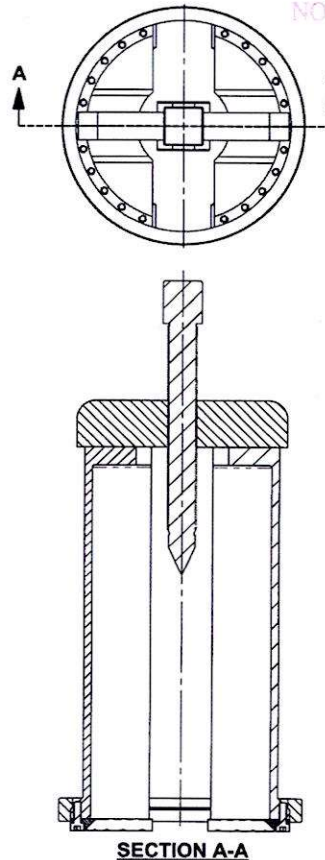
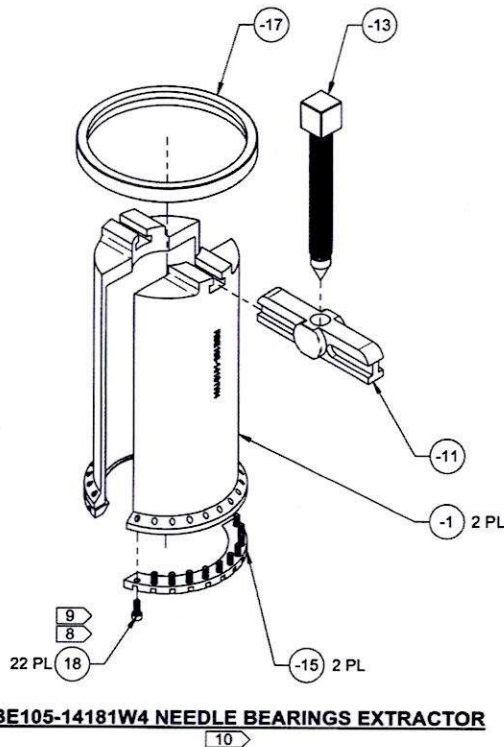
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91290A230	44	0	0
	RBE105-14181W4-1	4	0	0
	RBE105-14181W4-11	2	0	0
	RBE105-14181W4-13	2	0	0
	RBE105-14181W4-15	4	0	0
	RBE105-14181W4-17	2	0	0

Part Specifications

Specifications could not be found.

Plex 9/18/19 1:39 PM Dart.lajeunesse.marie

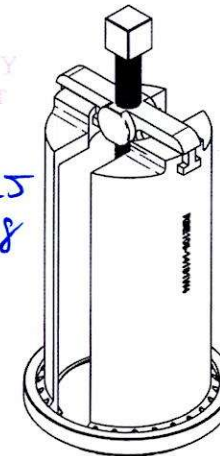
ITEM #	QTY	PART #	PART TITLE
-1	2	RBE105-14181W4-1	SHELL
-11	1	RBE105-14181W4-11	PULLER
-13	1	RBE105-14181W4-13	SCREW
-15	2	RBE105-14181W4-15	BASE
-17	1	RBE105-14181W4-17	CLAMPING RING
18	22	McMaster#91290A230 OR EQUIV	BLACK OXIDE STEEL SOCKET HEAD SCREW M5 X 0.8mm X 14mm LG.



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 18 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
 - 9) INSTALL ITEM 18 HAND TIGHT
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHO3 COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 200891 MJS
19-09-18



FOR OLDER REV'S SEE PREVIOUS PDFs
TEMPLATE UPDATED PER DART HBY STANDARDS
ITEM -1 WAS 3 PARTS ASSY IS ITEM -1 SINGLE PART
ITEM -3, -5 & -7 DELETED
ITEM -19 McMaster#93070A125 QTY 18 CHANGED FOR ITEM 18
McMaster#91290A230 QTY 22
ITEM -9 ASSY DELETED
ITEM -1 COMPLETE RE-DESIGN, FINISH CLEAR ANODIZE CHANGED
FOR RED ANODIZE
ITEM -11 DIMENSION 2X .725 +/- 0.005 CHANGED FOR 0.725,
DIMENSION 4X 2.00 CHANGED FOR 2.000 TYP, DIMENSION 4X .50
CHANGED FOR 0.500 TYP, DIMENSION 2X Ø1.34 CHANGED FOR
Ø1.340 TYP, DIMENSION .285 +/- 0.005 CHANGED FOR 0.285 TYP,
DIMENSION 2.685 REMOVED, DIMENSION 2X .275 REMOVED,
DIMENSION 1.275 CHANGED FOR 1.28, MATERIAL 4140/4142 Q&T
ZINC PLATE CHANGED FOR 4140 (28-32 RC) BLACK OXIDE,
DIMENSION 0.608 ADDED
ITEM -12 DIMENSION 1.0 CHANGED FOR 1.00, DIMENSION .325
CHANGED FOR .33, DIMENSION 5.25 AND 5.50 REMOVED,
DIMENSION 6.55 ADDED, DIMENSION 1.1 REMOVED, MIN THREAD
RELIEF ADDED, CENTER DRILL ADDED, MATERIAL 4140/4142 Q&T
ZINC PLATE CHANGED FOR 4140 (28-32 RC) BLACK OXIDE
ITEM -15 HEAT TREAT RC 45-50 CHANGED FOR 48-52 Rc, FINISH
ZINC PLATE CHANGED FOR ZINC PLATE YELLOW, DIMENSION .32
CHANGED FOR 0.315, DIMENSION Ø5.100 B.C CHANGED FOR
Ø5.236 B.C, DIMENSION 2.081 CHANGED FOR 2.087 +/- 0.001,
DIMENSION R2.145 REMOVED, DIMENSION R2.439 CHANGED FOR
Ø4.902 +/- 0.001, DIMENSION 8X 15° REMOVED, DIMENSION .561
REMOVED, DIMENSION 9X Ø.217 THRU ALL L L Ø.39 ± 0.20
CHANGED FOR Ø.217 THRU L L Ø.394 ± 0.20 9 PL EQ SP,
DIMENSION .650 REMOVED, DIMENSION Ø5.590 CHANGED FOR
Ø5.591/5.590
ITEM -17 MATERIAL 4140/4142 Q&T ZINC PLATE CHANGED FOR 4140
(28-32 RC) ZINC PLATE YELLOW, DIMENSION .30 CHANGED FOR 0.31,
DIMENSION Ø5.595 CHANGED FOR Ø5.596/5.595, DIMENSION .60
CHANGED FOR 0.61, DIMENSION Ø5.510 CHANGED FOR Ø5.492

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED			
DATE	2019-09-09		

TOOL PART #	RBE105-14181W4	REV. C
TITLE	NEEDLE BEARINGS EXTRACTOR	SHEET 1 OF 6
SCALE	NTS	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					